



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3715
Job Sheet 168245



Part No: 646.3715

Job Qty: 10 ea

Part Name: Strut Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/25/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 6 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/24/17	11/24/17	0.00	0.00	Start Up Container		SL 17/12/23
110	Waterjet	10 pcs	11/25/17	11/25/17	0.00	0.36	Waterjet1		SL 17/12/23
120	QC	10 pcs	11/25/17	11/25/17	0.00	0.00	QC2		SL 17/12/23
130	QC	10 pcs	11/25/17	11/25/17	0.00	0.00	QC8		38
140	Outsource	10 pcs	11/25/17	11/25/17			ATG001-VC	Outsource 4	AT 17/02/17
150	Packaging	10 pcs	11/25/17	11/25/17	0.00	0.00	Packaging2		AP 18/02/17
160	QC	10 pcs	11/25/17	11/25/17	0.00	0.00	QC5		38
190	Packaging	10 pcs	11/25/17	11/25/17	0.00	0.00	Packaging3	CK 115	9-30 FEB 13 2018
200	QC21-SA	10 Ea	11/25/17	11/25/17	0.00	0.00	QC21		21 FEB 14 2018

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O to ATG : P0038743

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040	0	41	0	0
	137980	0/6			

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:06 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ </td> <td style="width: 33%;"> Cross tube ☐ Small Fab ☐ Machining site ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐	Cross tube ☐ Small Fab ☐ Machining site ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐	Cross tube ☐ Small Fab ☐ Machining site ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

DART
 AEROSPACE
S026908

 Strut Doubler

A

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

PART NO: 646.3715
 Revision:
 Operation: Start up Operation
 Change No:

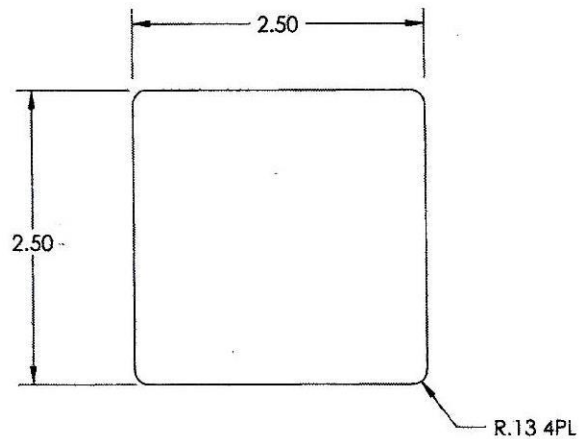
Mfg Date: 12/23/17
 Job No: 168245

Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOIM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3715

NEXT ASSY (S)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY P. BRAVO	CHECKED BY S. JOSEPH	DATE 08-18-08		
DRAWING APPROVAL S. JOSEPH	CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.000 ANGLES ±.5°		SHEET B	CAGE CODE 07M26	DWG NO 646.3700
SCALE 1:100		SHEET 6 OF 9		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

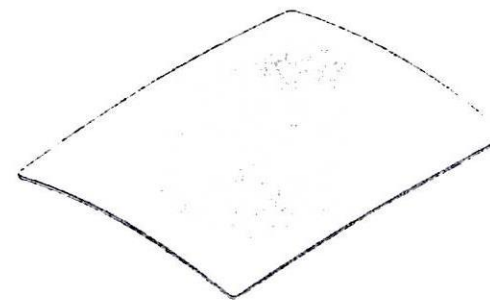
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISION		
REV	DESCRIPTION	DATE
A	INCORPORATED ECN 07118	01/03/09
		APPROVED

NOTES:

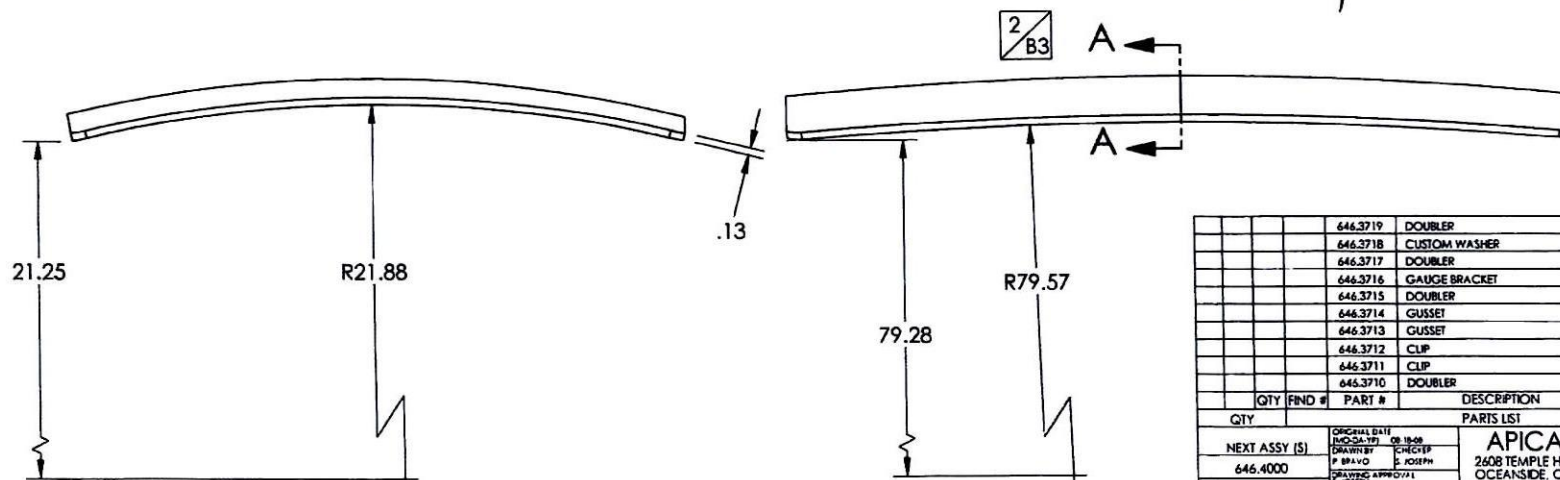
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

UNINCORPORATED ECN(s)

03702



			646.3719	DOUBLER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038743

PO Date: 1/8/18

Due Date: 2/1/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

JAN 23 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166820	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, Hard Black Anodize and Prime as per Dwg D4838-1 Rev. A	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$11.61/pcs	\$116.10
2	169613	D4703-043	Lock Pin Base Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, As Per Dwg D4703	Firmed	2/1/18	4 pcs	0 pcs	4 pcs	\$4.06/pcs	\$16.24
3	168229	646.3313	Upper Guide Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$14.46/pcs	\$86.76
4	168224	646.3210	Support Issue P/O to ATG: _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.71/pcs	\$94.26
5	168265	646.9710	Body Issue P/O to ATG: _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$15.86/pcs	\$190.32
6	165649	646.9811	Upper Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed	2/1/18	16 pcs	0 pcs	16 pcs	\$33.96/pcs	\$543.36
7	169180	649.5010	Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 649.5000 REV. D	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$35.36/pcs	\$176.80
8	169184	649.5214	Bracket Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per Dwg 649.5200	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$10.36/pcs	\$51.80
9	169748	650.9201		Firmed	2/1/18	20 pcs	0 pcs	20 pcs	\$7.96/pcs	\$159.20

JAN 24 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	169630	D4842-1	Eyelet Bracket Assembly Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	2/1/18	8 pcs	0 pcs	8 pcs	\$13.41/pcs	\$107.28
			Lower Cutter Deflector Outsource process- Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842				8x		18/02/02	
11	169388	647.7819	Cross Bracket Fwd Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 647.7819	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$12.61/pcs	\$126.10
12	168245	646.3715	Strut Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$7.61/pcs	\$76.10
							10x		AT 18/02/07	
13	168267	646.9712	Body Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.86/pcs	\$95.16
							6x		18/02/02	
14	168268	646.9713	Body Issue P/O to ATG : _____ Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$8.86/pcs	\$44.30
							5x		AT 18/02/07	
15	169381	647.1610	Wiper Deflector Fwd Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
							6x		AT 18/02/07	
16	169485	647.7612	Breakaway Tip Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
							6x		AT 18/02/07	
17	166816	D4823-1	Upper Cutter Deflector Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg D4823	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$12.51/pcs	\$150.12
							12x		AT 18/02/07	
Grand Total:									\$2,178.62	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914594

Date: 06-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22358	Rev: A	PO: PO038743 Line: 12
12 ea	Part: 646.9710 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing Job: 22352	Rev: D	PO: PO038743 Line: 5
5 ea	Part: 649.5010 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22354	Rev: D	PO: PO038743 Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>6/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914594

Date: 06-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity

Description

receipt.

Made in Canada.